Work Order Thursday, January	ID 65927 27, 2011 11:27:09 AM									Page 1	_
Revision ID: Item Name: W	7/2011 Start Qty: 5			Cust Item Customer:	ID:		s s	Setup Star Stop			= ·
• •	Process Plan:	Date:	7 Tooling: SPC (Y/N):		ate:	·	∖ F	Run Star Stop			
Sequence ID/ Work Center ID Draw Nbr	Operation Description		Set Up/ Run Hours	Tool ID			Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
D3537	Revision Nbr Rev C	•	• •								
Waterjet FLOW CNC Waterjet	FLOW WATER I Mem 1-Cu		0.00 0.00 Prog Rev:	□2-Deburr	٠.	_	PS11-	1-28			
QC Quality Control	QC2- Inspect part	ts off machine FAI/FAIB	0.00			-	K311-	-1-20		-	•
120 QC Quality Control	QC8- Inspect part		0.00	ulze		(ourt 749)	<i>n</i>	·		

Part No:	<u>-</u>	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
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Work Order ID 65927

Thursday, January 27, 2011 11:27:09 AM



Page 2

Item ID:

D3537-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Wearpad

Start Date:

1/27/2011 **Start Oty: 50.00**

Required Date: 2/7/2011

Req'd Oty: 50.00



Date:

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Date: _____

Tooling: SPC (Y/N):

Date: Date:

Tool # Plan

Code

Run Start

Reject

Oty

Accept

Qty

Stop

Reject



Number Stamp

Insp.

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Memo

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. \(\sigma\)2-

0.00 0.00

0.00

0.00

Set Up/

Run Hours

Identify as D3537-1

140

Large Fab

Large Fab

Large Fab

Memo

Memo

Description

Batch □ A/R

2059B Hardcoat 14/17/87. D1-Weld as per Dwg D3537 using Jig DT 8210 D2-Remove any

weld that penetrated through Wearpadif necessary

150

Quality Control

QC10- Inspect visual per QSI004- ground welds

EL 11-3-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11-3-9	150	Took 3) plotes for testing up new rod.	Z	11-3-9	3	4 1103eg	5 11/03/09	

Part No:	P	AR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORI	DER NON-CONFORMANC	INFORMANCE (NCR)						
		Description of NC		Corrective Action Section B	Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto			
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Work Order ID 65927

Thursday, January 27, 2011 11:27:09 AM



Page 3

Item ID:

D3537-1

Accept

Setup Start



Revision ID:

Item Name:

Wearpad

Start Date:

1/27/2011 Required Date: 2/7/2011

Start Oty: 50.00

Reg'd Qty: 50.00



Cust Item ID:

Customer:

Reference:

Approvals:

OC:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Un/

Run Hours

Date: Date: Run

Start

Stop

Stop



Sequence ID/

Work Center ID

160

QC

170

Powdercoat

Powder Coating

Operation Description

QC5- Inspect part completeness to step on W/O

Date:

Tool ID

Tool # Plan Code

Accept Otv

Reject Otv

Reject Number Stamp

Insp.

Ouality Control

Memo

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M.115128.

0.00

0.00

180

OC

Quality Control

OC3- Inspect Part Finish

0.00

Memo

0.00

16 Al 11-3-25

46 11/03/25

Dart	Aerospace	Ltd
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W/O:			W	WORK ORDER CHANGES								
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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	Re	esolution:	Dispositi	on:	QA: N/C C	osed:		Date: _				
NCR:		V	WORK ORI	DER NON-CONFORMA	NCE (NCF	R)		_				
DATE	OTED	Description of NC			n B	Verifi	cation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	& Section C		Chief Eng	QC Inspector			
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Work Order ID 65927

Thursday, January 27, 2011 11:27:09 AM



Page 4

Item ID:

D3537-1

Accept

Setup Start

Stop

Start



Revision ID:

Start Date:

Item Name:

Required Date: 2/7/2011

Wearpad

1/27/2011

Start Oty: 50.00

Reg'd Otv: 50.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:___

Tooling:

SPC (Y/N):

Date:

Date:

Stop

Run

Sequence ID/

Work Center ID

190

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Otv

Reject Insp. Number Stamp

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

CK 11/03/28 MF (1-03-98

Dart Ae	rospace	e Ltd		•						
W/O:			W	ORK ORDER CHAN	IGES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	Part No: PAR #:			tegory:	NCF	R: Yes N	lo DQ	A :	Date: _	
	R	esolution:	_ Dispositi	ion:	QA:	N/C Clo	sed:		Date: _	
NCR:				DER NON-CONFOR	MANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Descriptio	Section B	Sign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector
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Picklist Print

Thursday, January 27, 2011 11:27:15 AM

Work Order ID: 65927

Parent Item:

D3537-1

Parent Item Name: Wearpad



Start Date: 1/27/2011

Required Date: 2/7/2011

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No	·		100	sf	254.5000	0.106	5.578947			1 1 1
										1	B11-1-	28	

304/316 Sheet .063

Location .	Loc Oty	Loc Code	
MAT	254.5		
, 111323	0		
116623	254.5		116623

Dart Aerospace Ltd

W/O:			WO	RK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQ	A :	Date:	
	R	esolution:	Disposition	າ:	QA	: N/C CI	osed:		Date: _	
NCR:	·		WORK ORDE	ER NON-CONFO	DRMANCI	E (NCR	l)			
DATE	STEP	Description of NC	j	Corrective Action Section B			Verific	cation	Approval	Approval
DATE	SIEP	Section A	Initial Action Des Chief Eng Chief I				Sign & Section C		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	115927
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.254	*		U B02	
3.500	+/-0.010	3,499	>		ν	
1.965	+/-0.010	1.969	6	:	V	
2.795	+/-0.010	2,793	۵		V	
3.625	+/-0.010	3.622	٢		1/	
0.220 x 0.380	+/-0.010	238. × 286			V	
					-	
				•		
	-144					
						* ************************************

		``				

Measured by:	HB	Audited by:	2	Prototype Approval:	N/A
Date:	11-1-29	Date:	ulu126	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.03.21	New Issue	KJ/JLM	
В	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	1
С	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM 🔏	Gd

Dart Aerospa	ice Ltd
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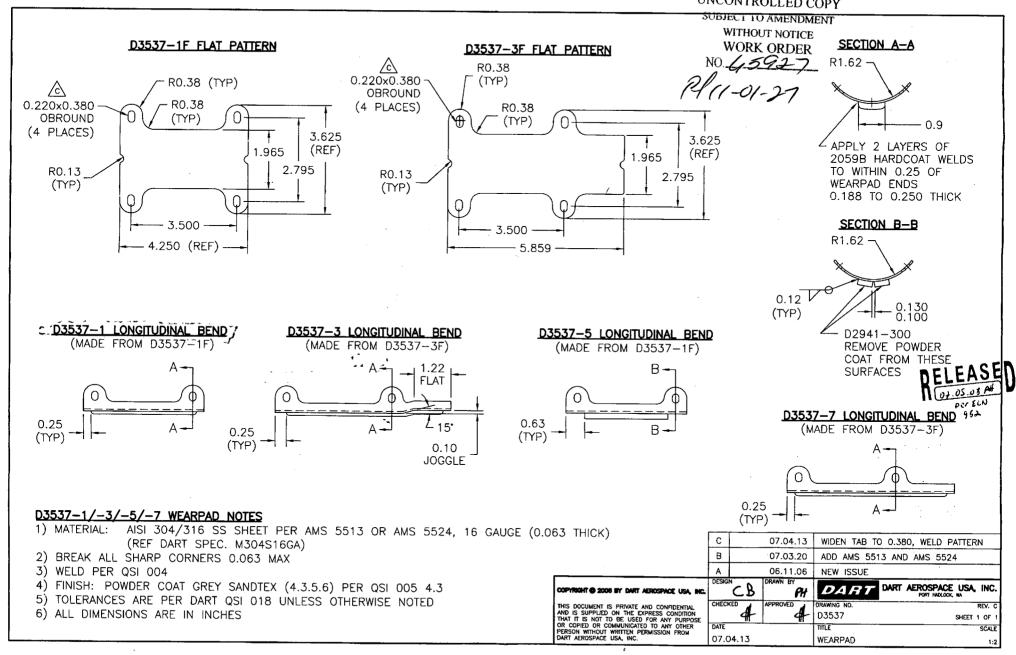
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W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	_ Fault Cat	egory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	_ Dispositi	on:	QA: N/C CI	osed:		Date: _	
NCR:		W	ORK ORI	DER NON-CONFORMA	NCE (NCF	1)			
	Τ.	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY



Dart .	Aero	space	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No: _		PAR #:	Fault Category:	 NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	 QA: N/C Closed:		Date:

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	Description of NC		Corrective Action Section B		Varification	Annual	Annuaval
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chief Eng Chief Eng	STEP Description of NC Section A Initial Chief Eng Chi	STEP Section A Initial Chief Eng Action Description Sign & Date Section C	STEP Description of NC Section A Chief Eng Corrective Action Section B Section C Section C Section C Chief Eng Chief